

§ 56.90-1

Heating a fabricated assembly as a complete unit is usually desirable; however, the size or shape of the unit or the adverse effect of a desired treatment on one or more components where dissimilar materials are involved may dictate alternative procedures. For example, it may be heated as a section of the assembly before the attachment of others or local circumferential-band heating of welded joints in accordance with 46 CFR 56.85-10, Table 56.85-10 Note (12) and 46 CFR 56.85-15(j)(3).

(e) Postheating treatment of welded joints between dissimilar metals having different postheating requirements must be established in the qualified welding procedure.

(f)-(h) [Reserved]

(i) For those materials listed under P-1, when the wall thickness of the thicker of the two abutting ends, after their preparation, is less than three-fourths inch, the weld needs no postheating treatment. In all cases, where the nominal wall thickness is three-fourths inch or less, postheating treatment is not required.

(j) (1)-(2) [Reserved]

(3) In local postheat treatment the entire band must be brought up to uniform specified temperature over the complete circumference of the pipe section, with a gradual diminishing of the temperature outward from the edges of the band.

[CGFR 68-82, 33 FR 18843, Dec. 18, 1968, as amended by CGD 72-206R, 38 FR 17229, June 29, 1973; CGD 73-254, 40 FR 40167, Sept. 2, 1975; USCG-2003-16630, 73 FR 65185, Oct. 31, 2008]

Subpart 56.90—Assembly

§ 56.90-1 General.

(a) The assembly of the various piping components, whether done in a shop or as field erection, shall be done so that the completely erected piping conforms with the requirements of the regulations in this subchapter and with the specified requirements of the engineering design.

§ 56.90-5 Bolting procedure.

(a) All flanged joints shall be fitted up so that the gasket contact faces bear uniformly on the gasket and then shall be made up with relatively uni-

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form bolt stress. Bolt loading and gasket compression need only be verified by touch and visual observation.

(b) When bolting gasketed flanged joints, the gasket must be properly compressed in accordance with the design principles applicable to the type of gasket used.

(c) Steel to cast iron flanged joints shall be assembled with care to prevent damage to the cast iron flange in accordance with § 56.25-10.

(d) All bolts must be engaged so that there is visible evidence of complete threading through the nut or threaded attachment.

[CGFR 68-82, 33 FR 18843, Dec. 18, 1968, as amended by USCG-2003-16630, 73 FR 65185, Oct. 31, 2008]

§ 56.90-10 Threaded piping (modifies 135.5).

(a) Any compound or lubricant used in threaded joints shall be suitable for the service conditions and shall not react unfavorably with either the service fluid or the piping materials.

(b) Threaded joints which are to be seal welded shall be made up without any thread compound.

(c) Backing off to permit alignment of pipe threaded joints shall not be permitted.

[CGFR 68-82, 33 FR 18843, Dec. 18, 1968, as amended by USCG-2003-16630, 73 FR 65185, Oct. 31, 2008]

Subpart 56.95—Inspection

§ 56.95-1 General (replaces 136).

(a) The provisions in this subpart shall apply to inspection in lieu of 136 of ASME B31.1 (incorporated by reference; see 46 CFR 56.01-2).

(b) Prior to initial operation, a piping installation shall be inspected to the extent necessary to assure compliance with the engineering design, and with the material, fabrication, assembly and test requirements of ASME B31.1, as modified by this subchapter. This inspection is the responsibility of the owner and may be performed by employees of the owner or of an engineering organization employed by the